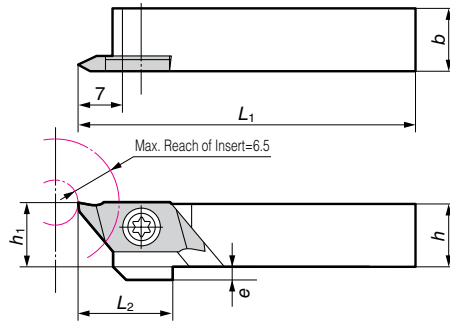
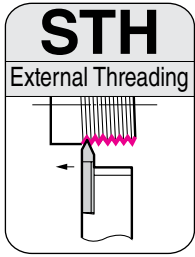


STH Type

External Threading

- Metric Threads
- Whitworth Threads

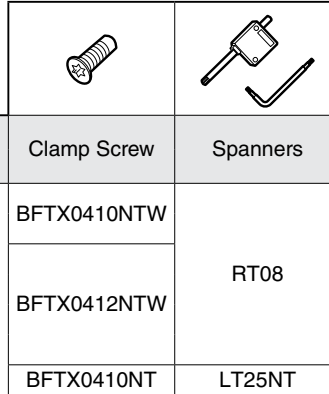


■ Holders

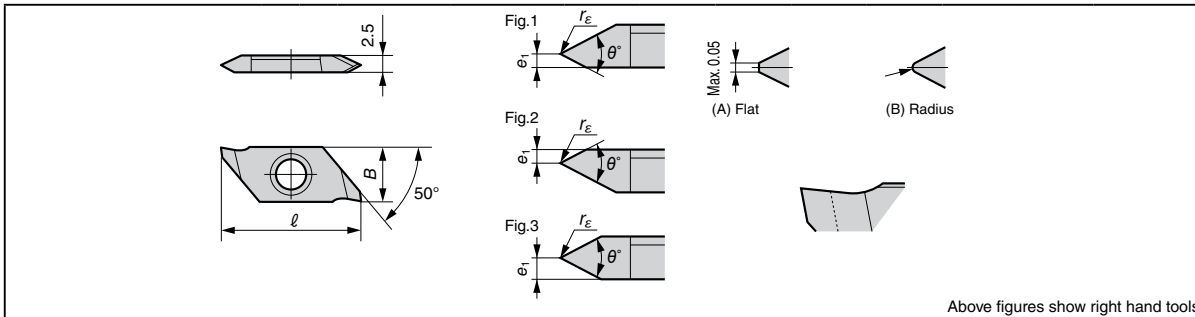
Above figures show right hand tools.

| Cat. No. | Stock | | Dimensions (mm) | | | | | | Applicable Insert | Clamp Screw | Spanners |
|--------------|-------|---|-----------------|----|----------------|----------------|---|----------------|-------------------|-------------|----------|
| | R | L | h | b | L ₁ | h ₁ | e | L ₂ | | | |
| STH R/L0810 | ● | ● | 8 | 10 | 120 | 8 | 4 | 15 | TH R/L Type | BFTX0410NTW | RT08 |
| STH R/L1010 | ● | ● | 10 | 10 | 120 | 10 | 2 | 15 | | | |
| STH R/L1212F | ● | ● | 12 | 12 | 85 | 12 | — | 15 | | | |
| STH R/L1212 | ● | ● | 12 | 12 | 120 | 12 | — | 15 | | | |
| STH R/L1616H | ● | ● | 16 | 16 | 100 | 16 | — | 15 | | | |
| STH R/L1616 | ● | ● | 16 | 16 | 120 | 16 | — | 15 | | | |
| STH R/L2020 | ● | ● | 20 | 20 | 80 | 20 | — | 15 | | BFTX0410NT | LT25NT |

■ Spare Parts



■ Inserts



Above figures show right hand tools.

| Cat. No. | Coated Carbide | | Pitch | | Dimensions (mm) | | | | | Fig. | Cutting Edge Shape | Applicable Holders |
|----------------|----------------|---|---------------|----------|-----------------|---|----------------|----------------|----|------|--------------------|--------------------|
| | ACZ150 | | mm | TPI | l | B | r _E | e ₁ | θ° | | | |
| | R | L | | | | | | | | | | |
| TH R/L6002075A | ● | ● | 0.20 to 0.75 | — | 20 | 8 | — | 0.40 | 60 | 1 | (A) | STH Type |
| TH R/L6002075B | ● | ● | 0.20 to 0.75 | — | 20 | 8 | — | 0.40 | 60 | 2 | (A) | |
| TH R/L6005125A | ● | ● | 0.50 to 1.25 | — | 20 | 8 | 0.05 | 0.80 | 60 | 1 | (B) | |
| TH R/L6005125B | ● | ● | 0.50 to 1.25 | — | 20 | 8 | 0.05 | 0.80 | 60 | 2 | (B) | |
| TH R/L601015N | ● | ● | 1.00 to 1.50 | — | 20 | 8 | 0.10 | 1.25 | 60 | 3 | (B) | |
| TH R/L550515A | ● | ● | 0.529 to 1.58 | 48 to 16 | 20 | 8 | 0.05 | 0.80 | 55 | 1 | (B) | |
| TH R/L550515B | ● | ● | 0.529 to 1.58 | 48 to 16 | 20 | 8 | 0.05 | 0.80 | 55 | 2 | (B) | |

■ Holder/Insert Combination

| Direction | Right Hand | | Left Hand | |
|------------------------|--|--|---|-------------------|
| | Guide Bush Side | Back Turning Side | Guide Bush Side | Back Turning Side |
| Cutting Edge Position | | | | |
| Threading Illustration | | | | |
| Toolholder | STH R (Right Hand) | STH R (Right Hand) | STH L (Left Hand) | STH L (Left Hand) |
| Insert | TH R ···· A | TH R ···· B | TH L ···· B | TH L ···· A |
| Characteristics | Often used in common tooling for a work that has a thread at its top end. In this type of tooling a necking width indicated with an arrow can be reduced since a cutting edge point is placed closer to the guide bush side. | Usually used when a thread is located in the middle or at the back-end of a work. In this type of tooling a necking width indicated with an arrow can be reduced since a cutting edge point is placed closer to the back turning side. | When a left hand holder is used, a sufficient cutting distance can be kept since the cutting edge point separates from the guide bush. For left hand holder, the meanings of A Type and B Type for the right hand holder are switched with each other. (B means the guide bush side while A means the back turning side.) | |